



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4711-041
Job Sheet 172182



Part No: D4711-041

Job Qty: 5 ea

Part Name: Expandable Pin Assembly, Modified



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/13/18

Job Tracking No:

Due Date: 2/26/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B 13.03.11 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	5 Ea	2/24/18	2/24/18	0.00	0.00	Start Up Stores/Pkg-1			DAS
110	Packaging	5 pcs	2/24/18	2/24/18	0.00	0.00	Packaging1-5			6
120	Small Fab	5 pcs	2/26/18	2/26/18	0.00	0.82	Small Fab-7			9-39
130	QC	5 pcs	2/26/18	2/26/18	0.00	0.00	QC5			DAS
140	Packaging	5 pcs	2/26/18	2/26/18	0.00	0.00	Packaging3-2	Still		6
150	QC21-SA	5 Ea	2/26/18	2/26/18	0.00	0.00	QC21			21

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4711-043	Expandable Pin Assembly	5 Ea (1 ea)	90-Start up Operation	
D4726-1	Handle	5 Ea (1 ea)	90-Start up Operation	
D4727-041	Barrel	5 Ea (1 ea)	90-Start up Operation	
D4749-1	Spacer	5 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4711-043	5	17	0
	D4726-1	5	6	0
	D4727-041	5	6	0
	D4749-1	5	19	0

Part Specifications

Specifications could not be found.

001044



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Container No: S043868



Part: D4711-041

Job No: 172182

Serial No/Batch: S043868

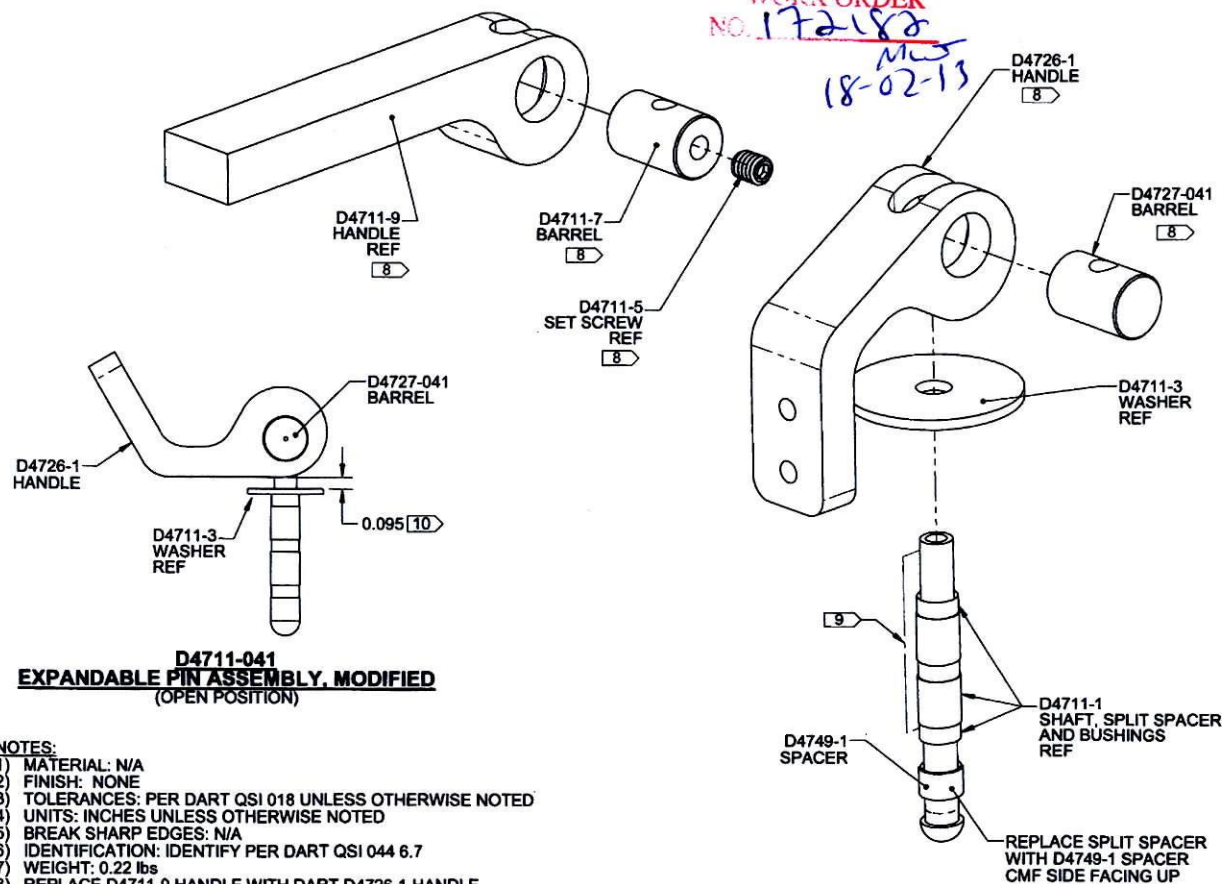
Revision: D4711

Inspector:

Date: 02/20/16

ITEM	QTY	P/N	DESCRIPTION
	X	D4711-041	EXPANDABLE PIN ASSY, MODIFIED
1	1	D4711-043	EXPANDABLE PIN ASSY
2	1	D4726-1	HANDLE
3	1	D4727-041	BARREL
4	1	D4749-1	SPACER

SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172182



D4711-041
EXPANDABLE PIN ASSEMBLY, MODIFIED
(CLOSED POSITION)

D4711-041
EXPANDABLE PIN ASSEMBLY, MODIFIED
(OPEN POSITION)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.7
- 7) WEIGHT: 0.22 lbs
- 8) REPLACE D4711-9 HANDLE WITH DART D4726-1 HANDLE.
REPLACE D4711-7 BARREL WITH DART D4727-041 BARREL.
REPLACE BOTTOM SPLIT SPACER WITH D4749-1 SPACER.
DISCARD D4711-5 SET SCREW, D4711-7 BARREL, D4711-9 HANDLE, BOTTOM SPLIT SPACER.
- 9) WHEN INSTALLING D4749-1 SPACER, ENSURE THAT ALL RETAINED SPLIT SPACERS AND BUSHINGS REMAIN IN THEIR ORIGINAL SEQUENCE AND ORIENTATION.
- 10) INSTALL THE D4711-1 SHAFT WITH THE ASSEMBLY IN THE OPEN POSITION, UNTIL A GAP OF 0.095" EXISTS BETWEEN THE D4711-3 WASHER AND THE D4726-1 HANDLE. DO NOT OVERTIGHTEN THE SHAFT INTO THE D4727-041 BARREL.

RELEASED
2016-01-05
ECN 15-614

APPROVED

D	GENERAL UPDATE MCMASTER CARR PART NO LONGER AVAILABLE SEE PREVIOUS REVISION AND PAR15-439 FOR DETAILS. SPLIT RINGS, CORE PIN & BARREL NOW 17-4PH H900 CONDITION.	AJS	15.07.22
C	REVISED NOTE (A4-1) & NOTE 8. ADDED NOTE 10. PICTORIAL UPDATE. ADDED VIEW B8-1.	AP	13.02.12
B	ADDED D4749-1 SPACER, MODIFIED NOTES 8 AND 9	AP	12.11.23
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4711	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ADJUSTABLE DIAMETER PIN	NTS
DATE	15.07.22	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									